

SHIP MAY 21

Work Order ID 116688

116688

Page 1

Wednesday, April 23, 2014 10:22:48 AM

Item ID: D4887-041L02

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Dome Light Air Vent Assembly, Black

Start Date: 4/24/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/21/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: *JA* Date: 14-4-23

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4887

PA10 REV A

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

(1) SMD 14/05/20

110

0.00

110

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D4887-041

1) Install air vents

2) Install lights

3) Install rheostats

4) Install wiring harness

(1) SMD 14/05/20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 116688***116688***

Page 2

Wednesday, April 23, 2014 10:22:48 AM

Item ID: D4887-041L02

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Dome Light Air Vent Assembly, Black

Stop ***NS2***

Start Date: 4/24/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/21/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

DAS

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

PPP 116688

1X 14-5-20

DAS
26
9-89

MLJ 14-05-21

MLJ 14-05-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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FAULT CATEGORY

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Picklist Print

Wednesday, April 23, 2014 10:22:53 AM

Page 1

Work Order ID: 116688

116688

Parent Item: D4887-041L02

D4887-041L02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 4/24/14

Required Date: 5/21/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 13/09/11 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4886-1		Manufactured	No			100	Each	16.0000	2	2			
D4886-1													
Air Vent													

Location Loc Qty Loc Code

ST137 16
109261 16

D4887-1L02		Manufactured	No			100	Each	0.0000	1	1			
D4887-1L02													
Dome Light Housing, Black													

D4897-043		Manufactured	No			100	Each	1.0000	1	1			
D4897-043													
Dome Light Wiring													

Location Loc Qty Loc Code

ST127 1
107770 1

D4898-1		Manufactured	No			100	Each	117.0000	12	12			
D4898-1													
Screw, Stainless Steel													

Location Loc Qty Loc Code

ST126 100
113458 100
ST127 17
107709 17

B119031

SAD 14/05/20

2
SAD 14/05/16

1
SAD 14/05/16

12
SAD 14/05/20

12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

Wednesday, April 23, 2014 10:22:53 AM

Page 2

Work Order ID: 116688

116688

Parent Item: D4887-041L02

D4887-041L02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 4/24/14

Required Date: 5/21/14

Start Qty: 1.00

Required Qty: 1.00

D4906-1

Manufactured No

100

Each

37.0000

2

2

D4906-1

Knob

**

SAD 14/05/20

Location

Loc Qty

Loc Code

ST126

37

107708

37

MS21042L06

Purchased No

100

Each

520.0000

12

12

MS21042L06

Nut

**

SAD 14/05/20

Location

Loc Qty

Loc Code

ST314

520

m127304

20

m127831

100

m128401

200

m128754

200

NAS1149F0663P

Purchased No

100

Each

418.0000

6

6

NAS1149F0663P

WASHER

**

SAD 14/05/20

Location

Loc Qty

Loc Code

ST295

418

M126083

18

M128591

400

NAS1149FN632P

Purchased No

100

Each

108.0000

12

12

NAS1149FN632P

Washer

**

SAD 14/05/20

Location

Loc Qty

Loc Code

ST295

108

m126926

108

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

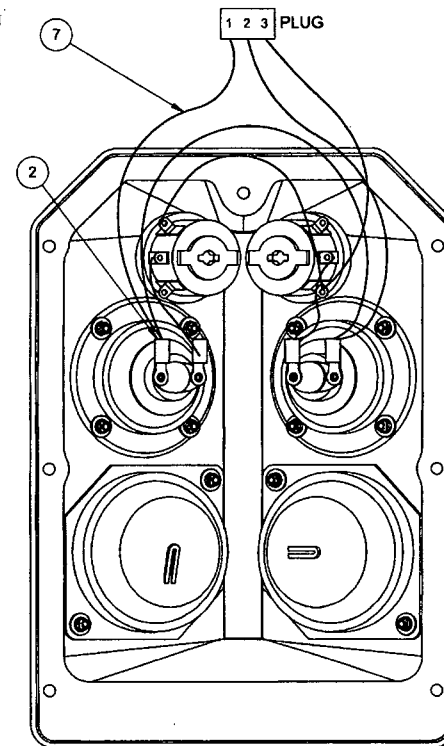
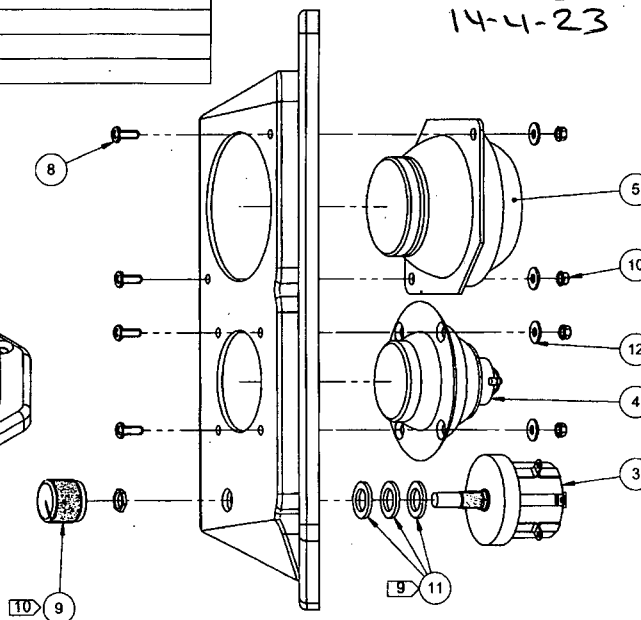
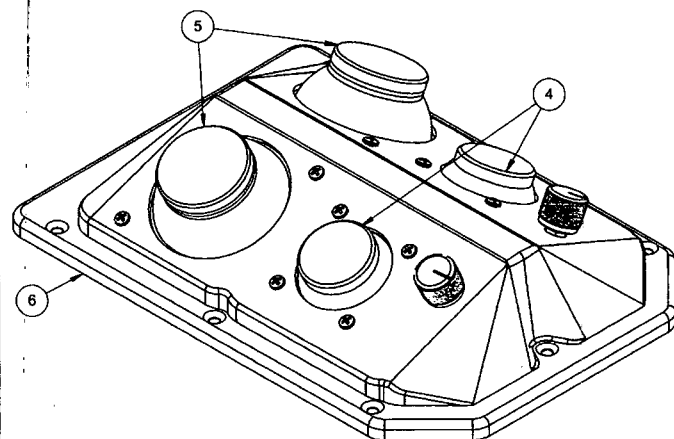
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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4887-041	DOMELIGHT AIR VENT ASSEMBLY
2	4	D4290-21 (REF)	RING TERMINAL (PART OF D4897-043)
3	2	D4864-3 (REF)	RHEOSTAT (PART OF D4897-043)
4	2	D4872-1 (REF)	LIGHT FIXTURE (PART OF D4897-043)
5	2	D4886-1	AIR VENT
6	1	D4887-1	DOMELIGHT HOUSING
7	1	D4897-043	DOMELIGHT WIRING HARNESS
8	12	D4898-1	SCREW
9	2	D4906-1	KNOB
10	12	MS21042L06	NUT
11	6	NAS1149F0663P	WASHER
12	12	NAS1149FN632P	WASHER



116688
14-4-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.43 lbs
- 8) REPLACES GENEVA P/N G12984 P112-XL
- 9) OPTIONAL: USE ADDITIONAL WASHERS TO SHIM AS REQUIRED
- 10) NUT INCLUDED WITH RHEOSTAT

D4887-041 DOMELIGHT AIR VENT ASSEMBLY

RELEASED
2013-09-16

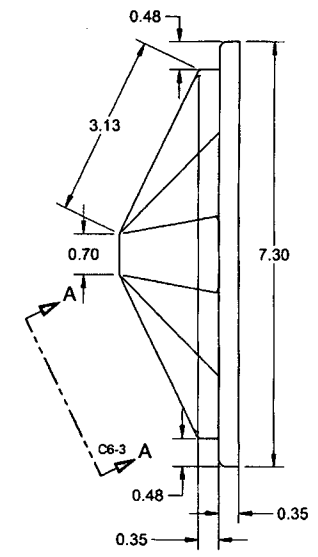
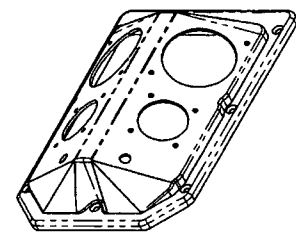
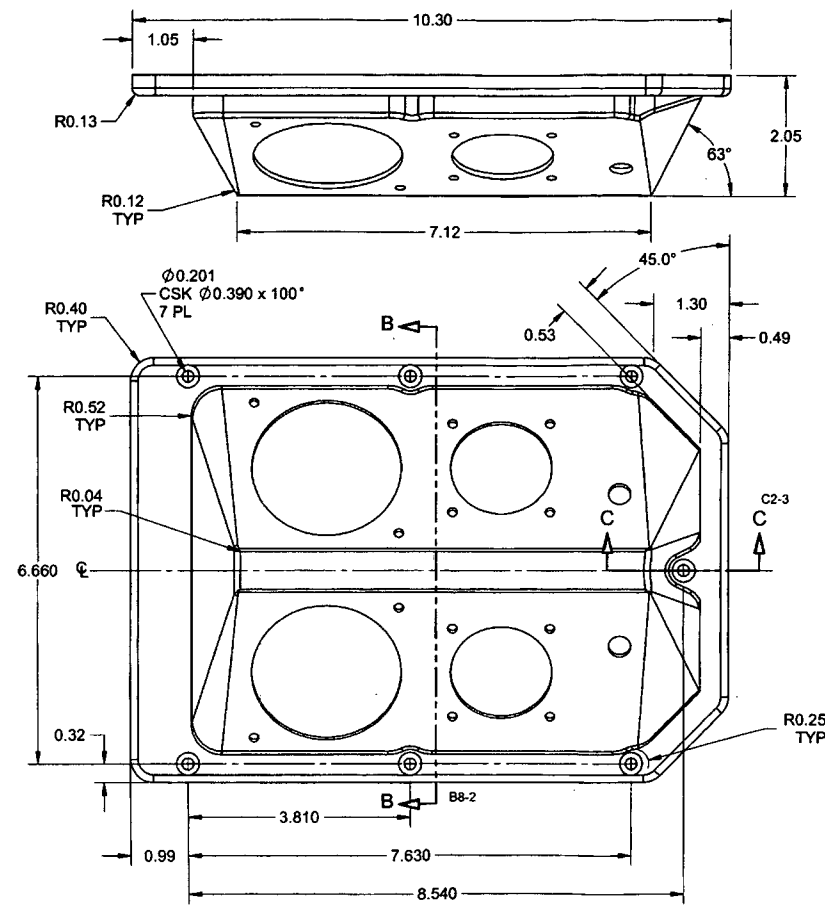
REV.	NEW ISSUE	BY	DATE
DESIGN			13.07.11
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.	
KENT, WA	
DRAWING NO.	REV. A
D4887	SHEET 1 OF 3
TITLE	SCALE
DOMELIGHT AIR VENT ASSY	NTS

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8 7 6 5 4 3 2 1

SECTION B-B
B5-2



RELEASED
2013-09-16
ml

D4887-1 DOME LIGHT HOUSING

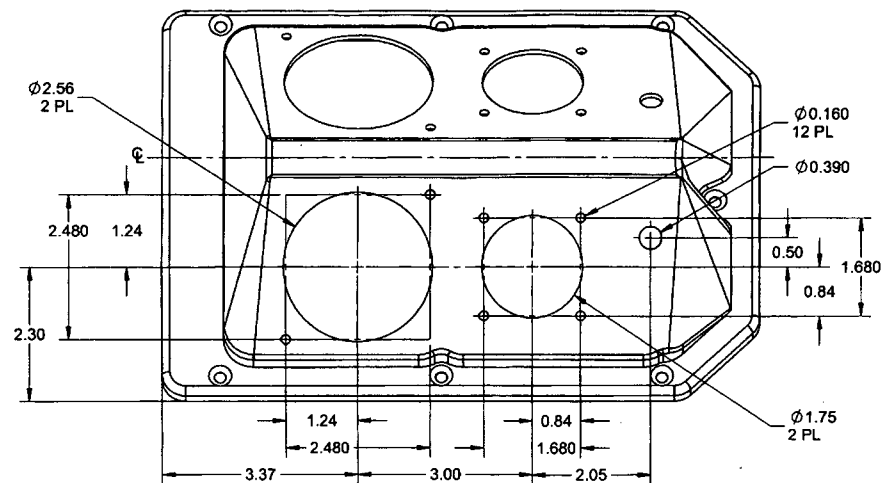
- NOTES:
 1) MATERIAL: SEE TABLE
 2) TOOLING: THERMOFORM PER MOLD DT9931 PER QSI 022 TRIM PER DT9931
 3) FINISH: N/A
 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 7) IDENTIFICATION: N/A
 8) WEIGHT: 0.34 lbs
 9) REPLACES GENEVA P/N G12986
 10) PART SHAPE AND GEOMETRY ARE CONTROLLED BY TOOLING
 11) MINIMUM THICKNESS AFTER FORMING IS 0.060" FOR FLANGES AND 0.070" ELSEWHERE

PART NUMBER	DESCRIPTION
D4887-1LBL	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-02)
D4887-1LLG	F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)

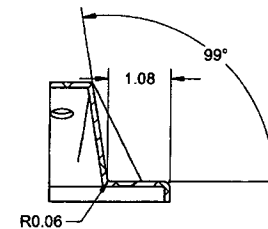
DESIGN	03
DRAWN	03
CHECKED	03
MFG. APPR.	03
APPROVED	03
DE APPR.	03
DATE	13.07.11

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D4887	REV. A
TITLE DOME LIGHT AIR VENT ASSY	SHEET 2 OF 3 SCALE NTS
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VIEW A-A 83-2



SECTION C-C
84-2

RELEASED
2013-09-16

DESIGN	OB	DART AEROSPACE USA, INC.	
DRAWN	OB	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	D4887	SHEET 3 OF 3
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	DOMELIGHT AIR VENT ASSY	NTS
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